



S017755

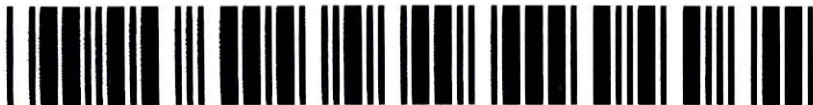
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Stud

PART NO: D2374

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/06/17

Job No: 168066



Dart Hawkesbury
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D2374

Job Sheet 168066



Part No: D2374

Job Qty: ~~42 ea~~
20

Part Name: Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Created By: Linda Lacelle

Due Date: 11/13/17

Description:

Note: DWG REV A IPP D 03.04.04 Reformat; Made on Cobra KJ/RF IPP Rev:E Now on Doosan Lathe 08-05-05
JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	11/11/17	11/11/17	0.00	0.00	Start Up Machining		<i>[Signature]</i> 17/12/05
100	Doosan	12 pcs	11/13/17	11/13/17	0.07	1.98	Doosan		<i>[Signature]</i> 17/12/05
120	QC	12 pcs	11/13/17	11/13/17	0.00	0.00	QC8		<i>[Signature]</i> 17/12/05
130	Packaging	12 pcs	11/13/17	11/13/17	0.00	0.00	Packaging3 GA		<i>[Signature]</i> 17/12/05
140	QC21-SA	12 Ea	11/13/17	11/13/17	0.00	0.00	QC21		<i>[Signature]</i> DEC 07 2017

Part Op 100 - 1- Turn as per Folio FA156 Rev: _____ & Dwg D2374 Rev: _____ 2- Mill as per Folio FA156 Rev: _____ & Dwg
Descriptions: D2374 Rev: _____ 3-Deburr per dwg D2374

Job Allocations

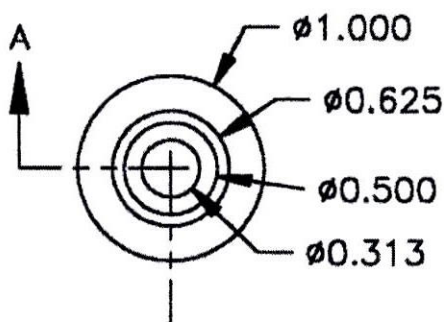
Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MDELRIINR1.000	2	10	0	0

Part Specifications

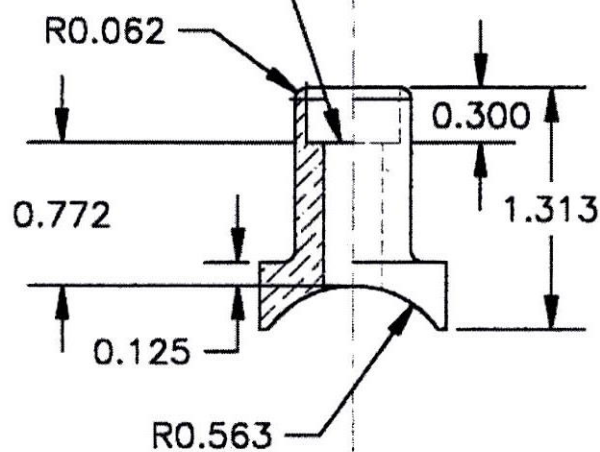
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stud	1.000Inches ± 0.010	0.997 0.990		
2	Stud	0.625Inches ± 0.010	0.623 0.615		
3	Stud	0.500Inches + 0.005 - 0.000	0.501 0.500	Diameter	
4	Stud	0.313Inches + 0.005 - 0.000	0.314 0.313	Diameter	
5	Stud	0.062Inches ± 0.010	0.062 0.052	Radius	
6	Stud	0.300Inches ± 0.010	0.310 0.290		
7	Stud	1.313Inches ± 0.010	1.308 1.303		
8	Stud	0.125Inches ± 0.010	0.120 0.115		
9	Stud	0.772Inches ± 0.010	0.763 0.762		
10	Stud	0.563Inches ± 0.010	0.565 0.573	Radius	



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED Bw	APPROVED	D2374	SHEET 1 OF 1
DATE 95:02:24		TITLE STUD	SCALE 1:1



COUNTER BORE
Ø0.500 X 0.300 DEEP
Ø0.313 THROUGH



SECTION A

MATERIAL: DELRIN BLACK

NOV 13 2017

DAS
30
9:39

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 168066

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					